

Work Order ID 67955

Tuesday, April 05, 2011 7:57:27 AM

Page 1

SHIP
APRIL 7th

Item ID: D3199-4

Accept

Setup Start

Revision ID:

Stop

Item Name: Bracket, Fwd RH

Start Date: 4/5/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3199

D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut as per Dwg D3199

Dwg Rev: D

Prog Rev: D

Deburr if required

B11-4-5

2

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B11-4-5

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Setup Start

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Start Date: 4/5/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				<u>42</u>			
130 Brake NC Brake NC	Bend as per dwg Small Fab Memo	0.00 0.00				<u>2</u>			
140 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				<u>42</u> -4			

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Page 3

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Revision ID:

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Start Date: 4/5/2011 Start Qty: 1.00

Required Date: 4/6/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00



Powdercoat

M 115128

0.00

Memo

START TIME: *1:40*
OVEN TEMPERATURE: *320°*
FINISH TIME: *2:10*

Powder Coating

2 *BR 11-4-6*

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 *φ M 11-4-6*

170

Identify as per dwg & Stock Location: *SWP*

0.00



Packaging

Memo

0.00

Packaging

P 4/4/12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

Work Order ID 67955

Tuesday, April 05, 2011 7:57:27 AM



Page 4

Item ID: D3199-4

Accept



Setup Start



Revision ID:

Stop



Item Name: Bracket, Fwd RH

Start Date: 4/5/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/6/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/4/79

11-09-7

②

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 05, 2011 7:57:34 AM

Page 1

Work Order ID: 67955



Parent Item: D3199-4



Parent Item Name: Bracket, Fwd RH

Start Date: 4/5/2011

Required Date: 4/6/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: RevC-prelim DD verified by:EC
11.03.31 as per ecn 11-531 DD verf:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S20GA

Purchased

No

100

sf

92.5000

0.1673

0.176105

1.



1B11-4-5

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

92.5

116437

28.5

116623

64

116437

2

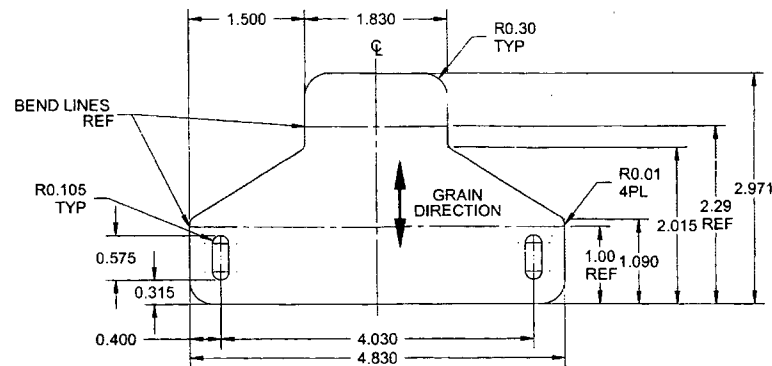
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

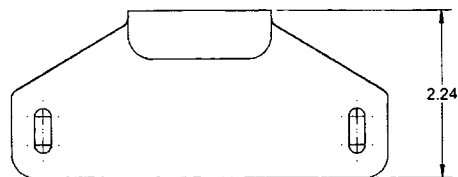
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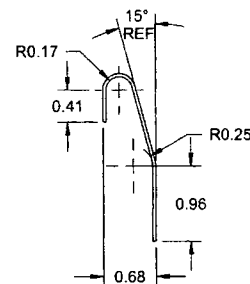
NOTE: Date & initial all entries



D3199-1F FLAT PATTERN



D3199-1 BRACKET
MADE FROM D3199-1F



NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFICATION: IDENTIFY WITH DART P/N "D3199-X" AND B/N "BXXXXX" PER QSI 044 6.1
- 7) WEIGHT: D3199-1 = 0.11 lbs, D3199-3/-4 = 0.26 lbs EACH

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67955

PR11-04-5

RELEASED
2011-03-31

D	RE-DESIGNED D3199-3/-4/-3F PER CUSTOMER FEEDBACK TO ELIMINATE BINDING OF DOOR ONCE BRACKETS ARE INSTALLED. REF: PAR11-79	MB	11.03.21
C	ADD -3/-4 PART (SHEET 2-4)	HS	09.11.19
B	2.24 WAS 2.142; ADD FINISH; UPDATE DWG	CB	06.11.01
A	NEW ISSUE	CP	03.08.05
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>JP</i>	DART AEROSPACE LTD	
DRAWN	<i>AS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>AS</i>	D3199	SHEET 1 OF 4
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	BRACKET	NTS
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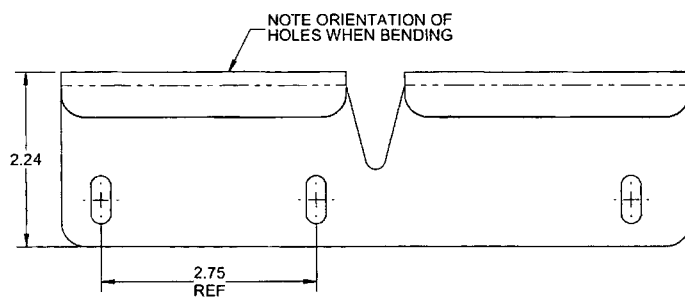
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

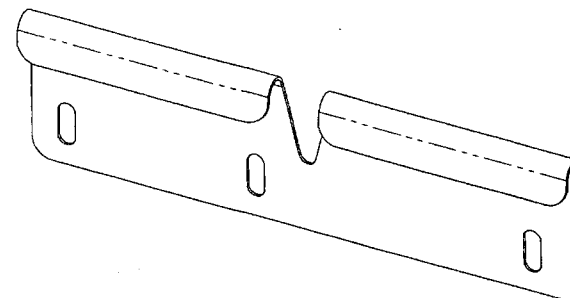
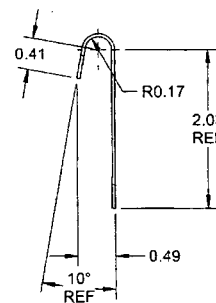
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3199-3 BRACKET
MADE FROM D3199-3F



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2011-03-31

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MFG. APPR.		D3199	SHEET 2 OF 4
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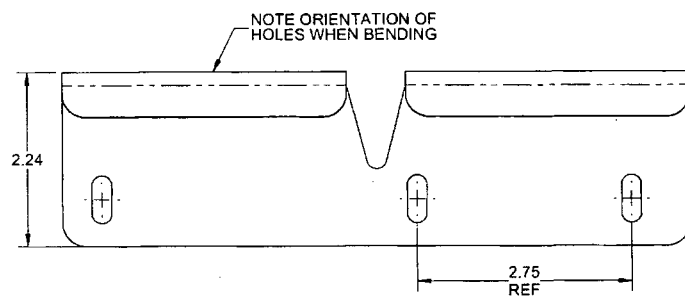
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

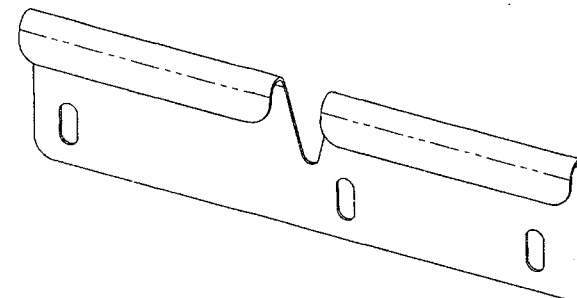
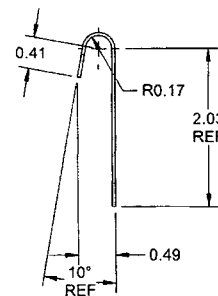
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3199-4 BRACKET
 D1 MADE FROM D3199-3F



u6 67955

RELEASED
 2011-03-31

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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3199	SHEET 3 OF 4
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DE APPR.		BRACKET	NTS
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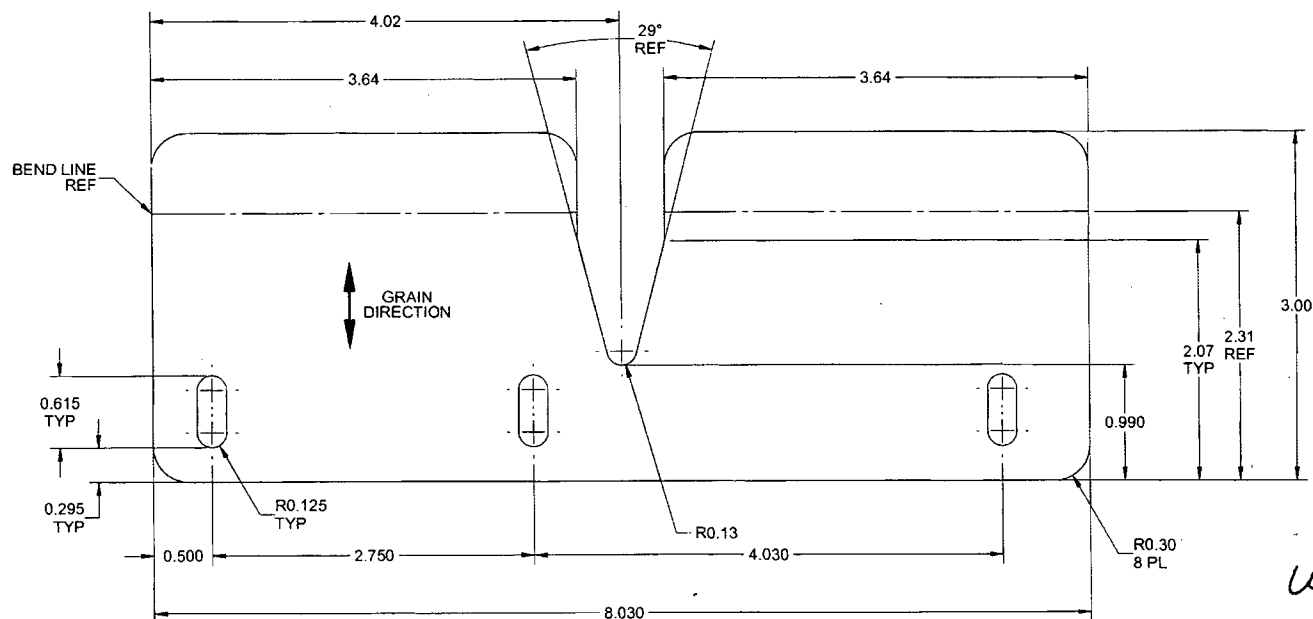
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D3199-3F FLAT PATTERN

RELEASED
2011-03-31

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.040 THICK, ANNEALED, 2B FINISH
PER MIL-S-5059, OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC M304S20GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.26 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3199	SHEET 4 OF 4
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